



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

5212510

RBST2812-P-5
Job Sheet 199224



Part No: RBST2812-P-5

Job Qty: 12 pcs

Part Name: Roller



Part Weight: 0 lbs

Job Created: 8/14/19

Due Date: 9/18/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: DWG RBST2800-P Rev. 1 IPP Rev. A 18.06.21 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	12 pcs	9/18/19	9-8	0.00	0.00	Workcenter / Supplier Lead Time Purchasing - 1 8 Purchasing - 2 8 Purchasing - 3 8	
110	Packaging 2-1 - Receive - B4B	12 pcs	9/18/19		0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B Packaging 2 - 17 - B4B Packaging 2 - 18 - B4B Packaging 2 - 19 - B4B Packaging 2 - 20 - B4B Packaging 2 - 21 - B4B Packaging 2 - 22 - B4B Packaging 2 - 23 - B4B Packaging 2 - 24 - B4B Packaging 2 - 25 - B4B Packaging 2 - 26 - B4B Packaging 2 - 27 - B4B Packaging 2 - 28 - B4B	



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CANADA
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www.dartaerospace.com

Container No: S212510



Part: RBST2812-P-5

Job No: 199224

Serial No/Batch: S212510

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 09/11/19

DP SEP 11 2019

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	12 pcs	9/18/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	DAS
					QC 6 - 40	81
					QC 6 - 81	9-89
						SEP 17 2019
130 Packaging 3-1 - Stock - B4B	12 pcs	9/18/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC
					Packaging 3 - 24 - B4B	GA/38
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					DAS	
140 QC 21 - SA	12 pcs	9/18/19	0.00 0.00		QC 21 - SA - 21	21
					QC 21 - SA - 70	9-89
					QC 21 - SA - 53	
						SEP 17 2019

Part Op 100 - ISSUE P/O: 44319 TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF

Descriptions: 89031009 ***NOTE*** One dowel pin makes 6 pcs.

110 - (Receive & Inspect for Damage & Mat'l Certs)

120 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location:)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
89031009	Plug and Pin Gauge	1.9920 Ea (.166 ea)	100-Purchasing	5049637
RBST2812-P-5P	Roller	12 Ea (1 ea)	110-Packaging 2-1 - Receive - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	89031009	2	25	0
110-Packaging 2-1 - Receive - B4B	RBST2812-P-5P	12	0	0

Remove from BOM

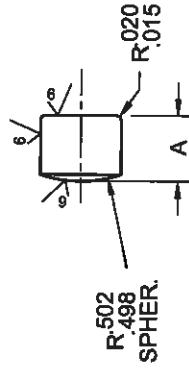
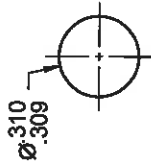
Part Specifications	
Specifications could not be found.	

Plex 8/21/19 3:49 PM Dart.Guerin.Kimberley

5208079
5212460

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REVISIONS		
REV	DESCRIPTION	DATE



(5)

ROLLER

TOOL #	A	MATERIAL
RBST2812	.251	.310 MINUS GAUGE PIN MSC #89031009

RED BARN MACHINE	
TITLE RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. TOOL#(see chart)-5 ROLLER	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
XXX ± .005	ANGLES ± 5°
XX ± .01	
X ± .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES TO 1/16" X 45° R .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-9-09
DRAWN BY: PERRITT	
APPROVED: <i>[Signature]</i>	
TREAT: RC 55-60	
FINISH: SPEC	
USED ON BEARING	
SEE CHART	
SHEET 4	OF 9

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng, Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality		DEPARTMENT/PROCESS		MRB (QS042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Root Cause		Completed By					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Lead hand / Supervisor					
QC / QA Coordinator		QC / QA Coordinator					
Fault Category		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread					
Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function					
Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up					



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PURCHASE ORDER

POHB044319



Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

PO No: POHB044319
PO Date: 8/22/19
Due Date: 9/3/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
2019-08-27

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199257	RBST4241-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 ***NOTE*** One dowel pin makes 6 pcs.	Firmed -		9/3/19	24 pcs	0 pcs	24 pcs	\$16.00/pcs	\$384.00
				X24		SEP 11 2019	5212	512			DP
2	199224	RBST2812-P-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 ***NOTE*** One dowel pin makes 6 pcs.	Firmed -		9/3/19	12 pcs	0 pcs	12 pcs	\$16.00/pcs	\$192.00
				X12		SEP 10 2019	5212	510			DP
3	196252	RBSC7028-P-5	Cutter 1-Issue P/O to KG Grinding; P/O _____ 2-Grind as per DWG. RBSC7###-P-5 Rev6 3- Certificate of Conformity is required	Firmed -		9/3/19	10 pcs	0 pcs	10 pcs	\$60.00/pcs	\$600.00
				X10		SEP 10 2019	5203	376			DP

Grand Total: \$1,176.00

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PURCHASE ORDER

POHB044319



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/27/19 9:04 AM Dart.Guerin.Kimberley

AFFUTAGE K.G. INC. K.G. GRINDING INC.

11455 avenue Philippe Panneton
Montréal, Québec H1E 4M1
Tel: (514) 323-0192
Fax: (514) 323-6631

Packing Slip

Packing Slip No.:

11228

Date:

04-09-2019

Page:

1

Sold to:	Ship to:
DART AEROSPACE LTD CHANTAL LAVOIE 1270 Aberdeen Street Hawkesbury, On K6A 1K7	DART AEROSPACE LTD CHANTAL LAVOIE 1270 Aberdeen Street Hawkesbury, On K6A 1K7
Order No.: HB044319	Sold By:
Shipped By:	Tracking No.:

Item No.	Unit	Description	Ordered	Quantity Shipped	B/O
D.Modification	Each	DOWEL PIN MODIFIED TO RBST4241-5	24	24	
D.Modification	Each	DOWEL PIN MODIFIED TO RBST2812-P-5	12	12	
D.Modification	Each	TOOL MODIFIED TO RBSC7028-P-5	10	10	
RECEIVED SEP 06 2019 DART AEROSPACE LTD.					